METHOD FOR MANUFACTURING THE SAME

FIG.1

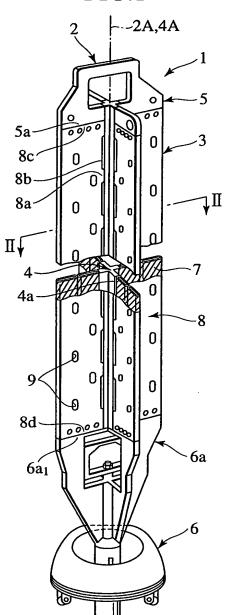
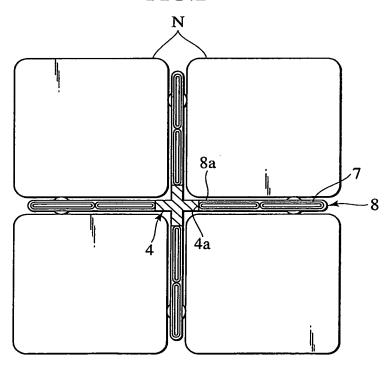
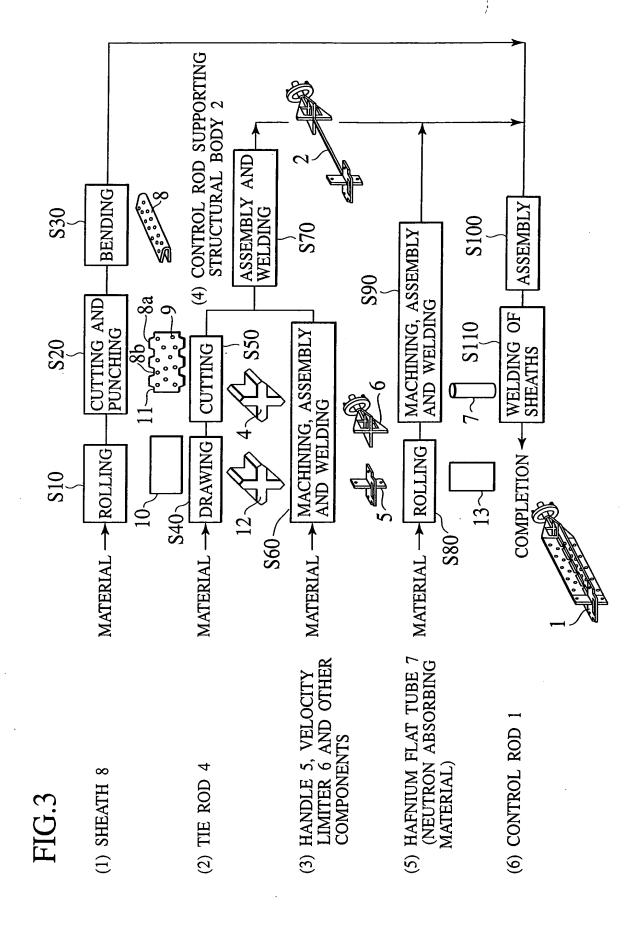


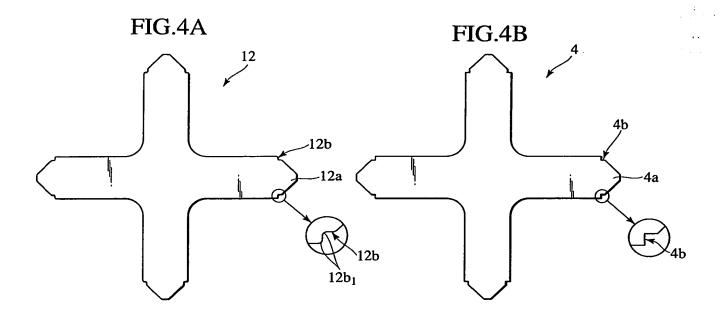
FIG.2

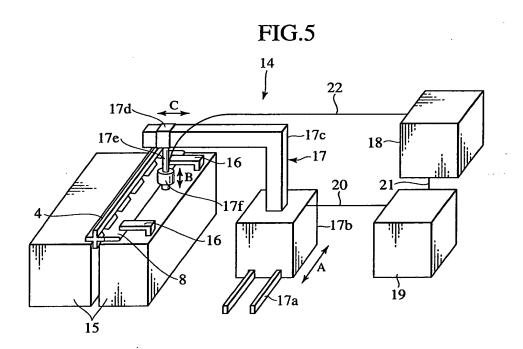


App No.: Not Yet Assigned Inventor: Michio Nakayama et al. Docket No.: H6810.0071/P071-B

Title: CONTROL ROD FOR BOILING WATER REACTOR AND METHOD FOR MANUFACTURING THE SAME







App No.: Not Yet Assigned Diventor: Michio Nakayama et al. Docket No.: H6810.0071/P071-B

Title: CONTROL ROD FOR BOILING WATER REACTOR AND METHOD FOR MANUFACTURING THE SAME

FIG.6

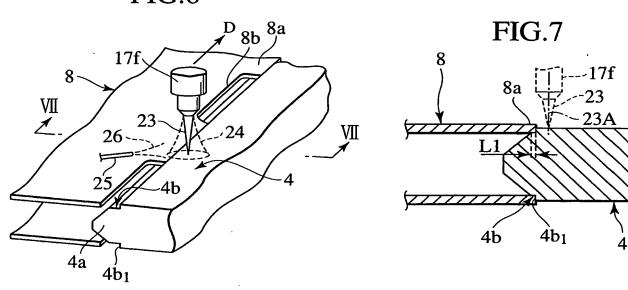


FIG.8

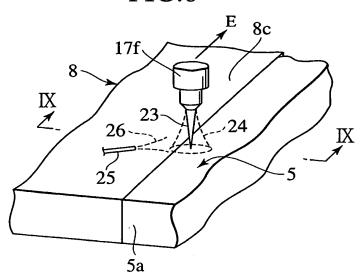
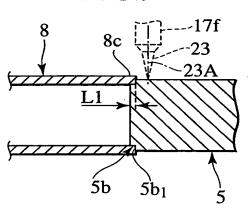


FIG.9



App No.: Not Yet Assigned Inventor: Michio Nakayama et al. Docket No.: H6810.0071/P071-B

Title: CONTROL ROD FOR BOILING WATER REACTOR AND

METHOD FOR MANUFACTURING THE SAME

FIG.10

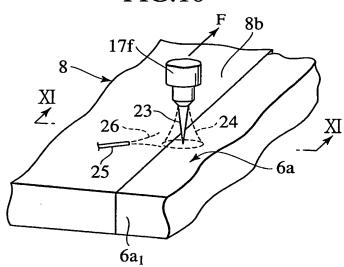


FIG.11

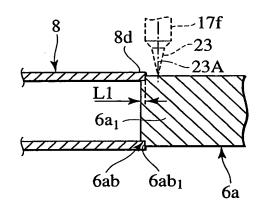
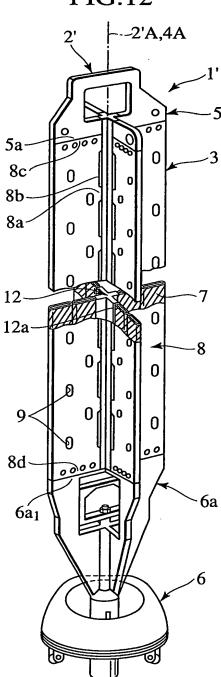


FIG.12



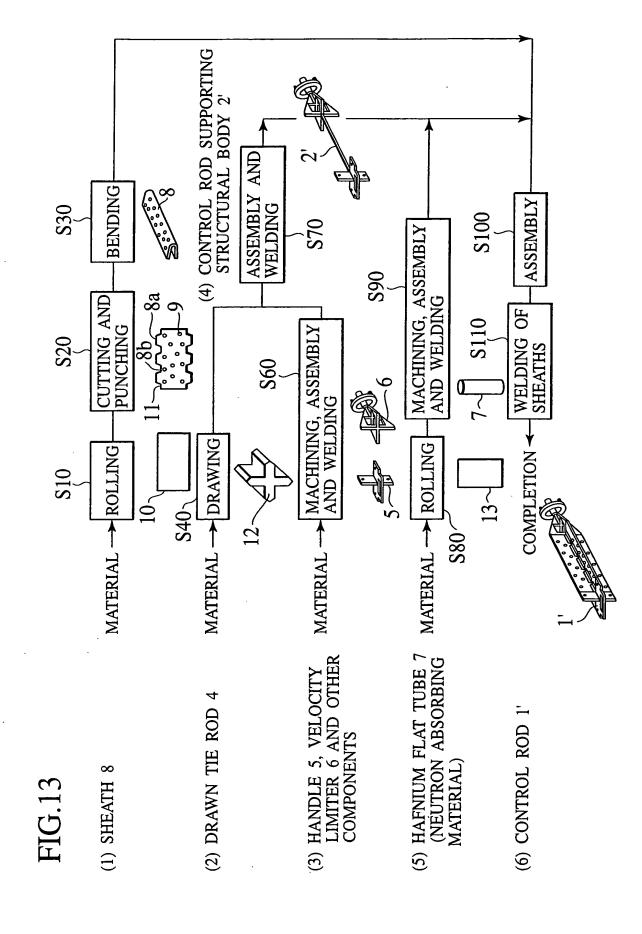


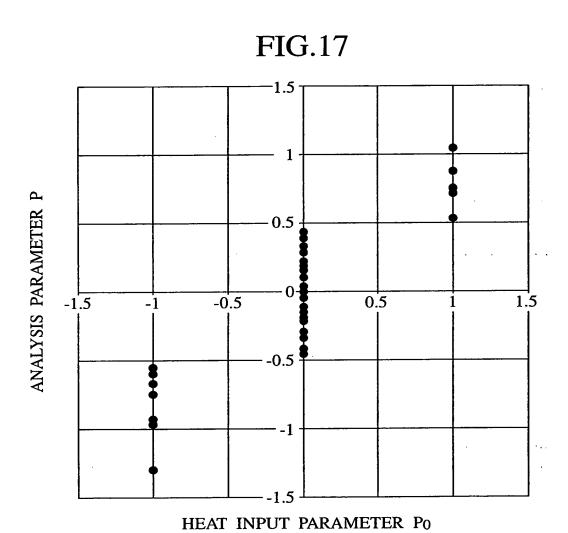
FIG.14 FIG.15 G 8b ,8a 17f --17f 8 8a XV Z 23 26 -12 -12b 12b 12b₁ 12 12b₂ 12a

FIG.16

MODE OF YAG LASER OUTPUT	CONTINUOUS WAVE
WELDING LENGTH (mm)	30
NUMBER OF WELDING PASSES	1
TRAILER GAS, SHIELDING GAS	N ₂
DIAMETER (mm) OF WELDING ROD 30	0.6
GAP (mm) BETWEEN TIE ROD 4 AND SHEATH 8	0~0.3
DISTANCE (mm) FROM EDGE OF SHEATH PROJECTION 8A TO BEAM CENTRAL AXIS 23A (WHEN DIRECTION TOWARD SHEATH 8 IS POSITIVE, AND DIRECTION TOWARD AXIS CENTER 4A OF TIE ROD 4 IS NEGATIVE)	-0.5~0.5
HEAT INPUT (kJ/cm)	0.69~1.63
CONVERGING DIAMETER (mm)	0.57~0.98
SUPPLY (g/m) OF CONTROL ROD 30 FOR ONE METER OF WELDING	1.25~4.06
OVERLAP (mm) OF TIE ROD 4 WITH SHEATH 8	0.2~0.8

Docket No.: H6810.0071/P071-B App No.: Not Yet Assigned Inventor: Michio Nakayama et al.

Title: CONTROL ROD FOR BOILING WATER REACTOR AND METHOD FOR MANUFACTURING THE SAME



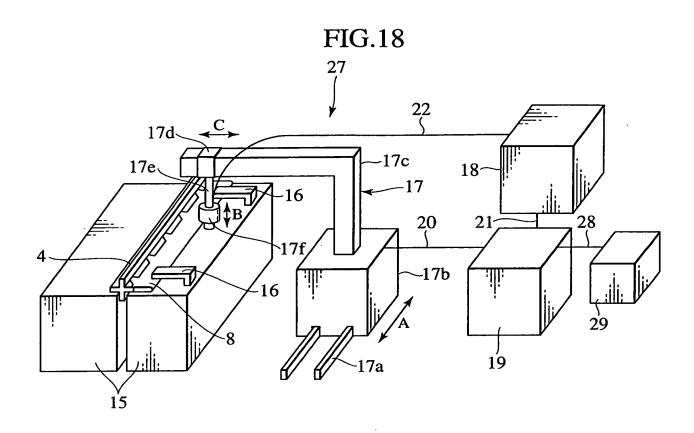


FIG.19 XXI≺ **FIG.20** 4b₂ 8a XX Н 8b₁ 8a₁ 8a 8b 8a XXI≺

FIG.21

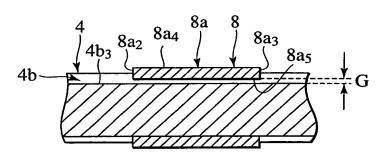


FIG.22

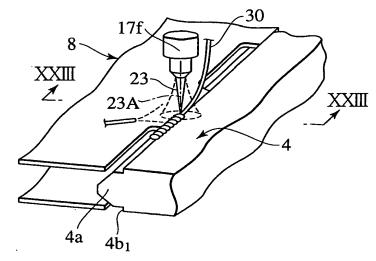


FIG.23

